

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REDUCER TEE ASSY
Job Number	: 31779		
Estimate Number	: 12762		
P.O. Number	: <i>N/A</i>	Part Number	: 41232 200 004 001
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: 41232-200-004 REV IR
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: IR
Previous Run	: 31018	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 5/10/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i> <i>07.04.12</i>		
Comment	: Est Rev:A New Issue 07-03-01 JLM		

Job Number:

1.0	AN8154J	union
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union

Batch: M104253

2.0	AS1035J080812	TÉE
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TEE

Batch: M104197

3.0	LATHE CONV.	CONVENTIONAL LATHE
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2-Deburr as Required.

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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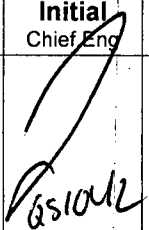
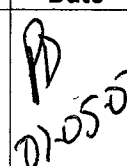

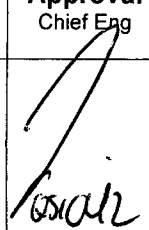

Comment: ~~CONVENTIONAL MILLING MACHINE~~

1-Drill as per Dwg 41232-200-004

2-Debut

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/30	4.0	1 part scrap, setup error		Scrap part	 07-05-07	 07/05/07		 07/05/07

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REDUCER TEE ASSY

Job Number: 31779

Part Number: 41232 200 004 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS

07/04/30

19

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3G

07.04.30

19

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg 41232-200-004

A/R SS Rod

Batch:

M102756

07/05/07

19

8.0

QC5/9

WELD INSPECTION



Comment: 1-WELD INSPECTION

07-05-07

19

2-Pressure test as per Dwg 41232-200-004

07-05-08

19

4- Passivate Finish.

3- Pickling Paste

07-05-08

Soudotec Passivating Solution 623745

M102991

Soudotec Pickling Paste 624809

3/1 M102991

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/05/08 7/5/8 SP

19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



19

Comment: FINAL INSPECTION/W/O RELEASE

07/05/10

Job Completion



07/05/09

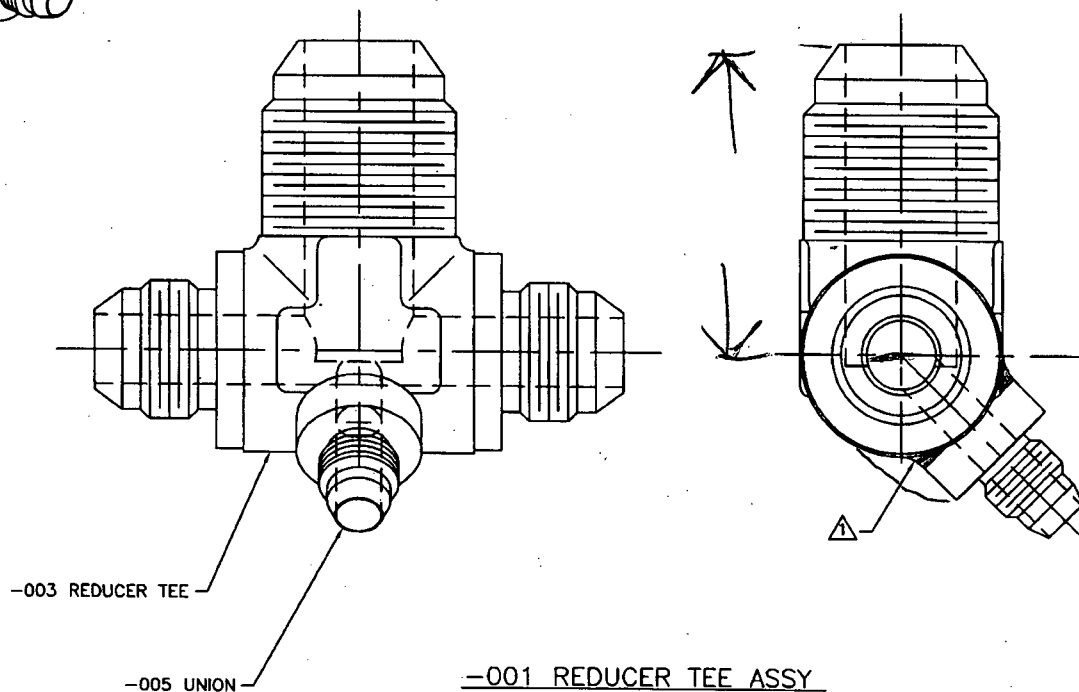
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

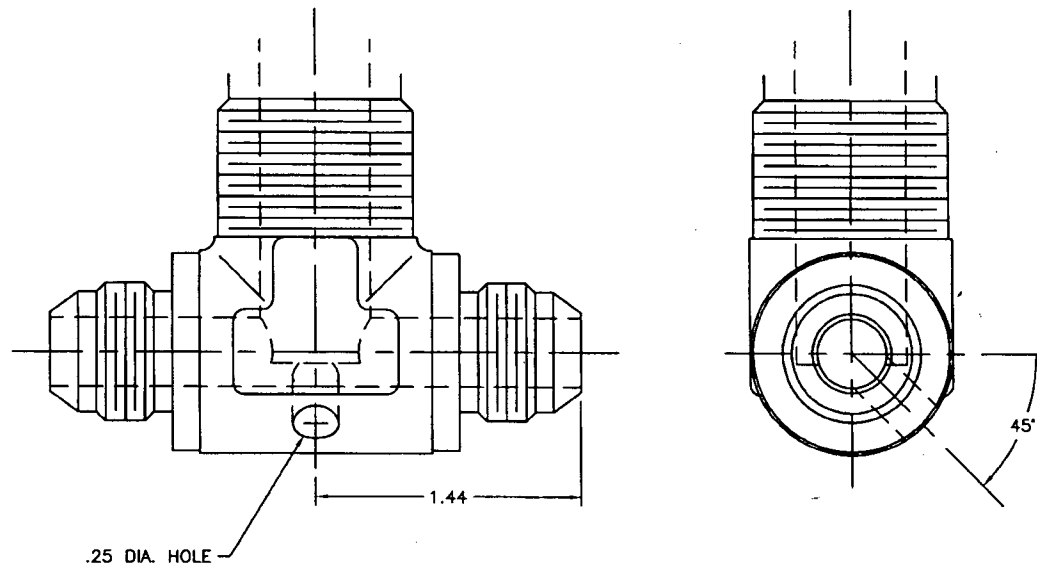
NOTE: Date & initial all entries



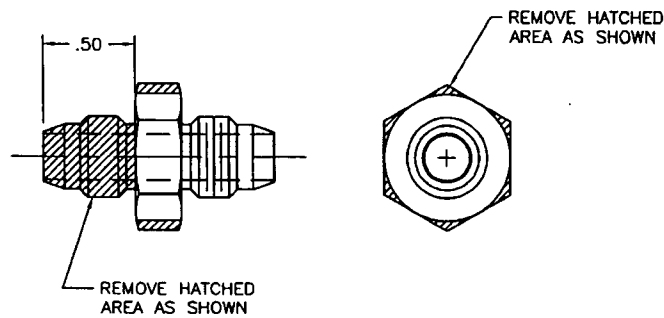
- ③ PRESSURE TEST TO 3,000 PSI.
- ② QQ-P-35 PASSIVATE FINISH AFTER WELD.
- ① WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

NOTES:

				1	-005	UNION	MAKE FROM AN815-4J UNION				
				1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-12C				
				1	-001	REDUCER TEE ASSY					
				-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC		
NO. REQ'D PER ASSY					LIST OF MATERIAL					ZONE	
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						X ± 1	CHECK	D. MURPHY	5/24/02	REDUCER TEE ASSY	
						XOL ± .03	STRESS				
						XOL ± .010	PROD. ENGR.			DWG. SIZE C SCALE 2:1	
						ANGLES ± 1/2°	HEAT TREAT			DWG. NO. 41232-200-004	
										REV.	
				-001	2	41232-000-001	Era Aviation, Inc.			SHT 1 OF 2	IR
						NEXT ASSEMBLY					



-003 REDUCER TEE



-005 FITTING

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WITHOUT NOTICE
WORK ORDER
31779

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Era Aviation, Inc.

REDUCER TEE ASSY

SIZE
C

DATE REC.
41232-200-004
SHT 2 OF 2

REV.
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